

WHAT IS CLAIMED IS:

1. A cushion structure used as a seat cushion or backrest of a seat, comprising a square net stretched on a square frame of combined structure composed of an elastic square frame body and a hard square frame body embedded in the elastic square frame body, wherein each side end portion of said square net is rolled up on the elastic square frame body of said square frame and fastened to the hard square frame body of said square frame.

2. A cushion structure as claimed in Claim 1, wherein a mounting plate adhered to each side end portion of said square net is fastened to the hard square frame body of said square frame.

3. A cushion structure as claimed in Claim 1, wherein the elastic square frame body of said square frame is made of sponge, and wherein the hard square frame body of said square frame is made of metal.

4. A manufacturing method of a cushion structure having a surface formed with a square net which is rolled up on a square frame at each side end portion thereof and stretched on the square frame by fastened thereto, comprising the steps of :

- retaining a square net on a support bed in a flat condition;
- placing a square frame in position on the square net retained on the support bed;
- pressing the square frame toward the square net to roll up each side end portion of the square net on each frame portion of the square frame; and
- fastening each side end portion of the square net to each frame portion of the square frame.

5. A manufacturing method of a cushion structure the surface of which is formed with a square net rolled up on a square frame at each side end portion thereof and stretched on the square frame by fastened thereto, comprising the steps of:

- retaining a square net on a support bed in a flat condition;
- placing a square frame of combined structure in position on the square net retained on the support bed, said square frame being composed of an elastic square frame body and a hard square frame body embedded in the elastic square frame body;
- pressing said square frame of combined structure toward the square net to roll

up each side end portion of the square net on each frame portion of the elastic square frame body of said square frame; and

fastening each side end portion of the square net to the hard square frame body of said square frame.

6. A manufacturing apparatus of a cushion structure the surface of which is formed with a square net rolled up on a square frame at each side end portion thereof and stretched on the square frame by fastened thereto, comprising:

a square support bed for retaining a square net thereon in a flat condition;

a plurality of clamping mechanisms mounted on said support bed for clamping each side end portion of the square net retained on said support bed; and

a plurality of pressure mechanisms mounted on said support bed for pressing a square frame placed on the square net clamped by said clamping mechanisms so that each side end portion of the square net is rolled up on each frame portion of said square frame.

7. A manufacturing apparatus of a cushion structure as claimed in Claim 3, wherein said clamping mechanisms are arranged in pair on each side portion of said support bed, and wherein said pressure mechanisms are arranged on each corner portion of said support bed.